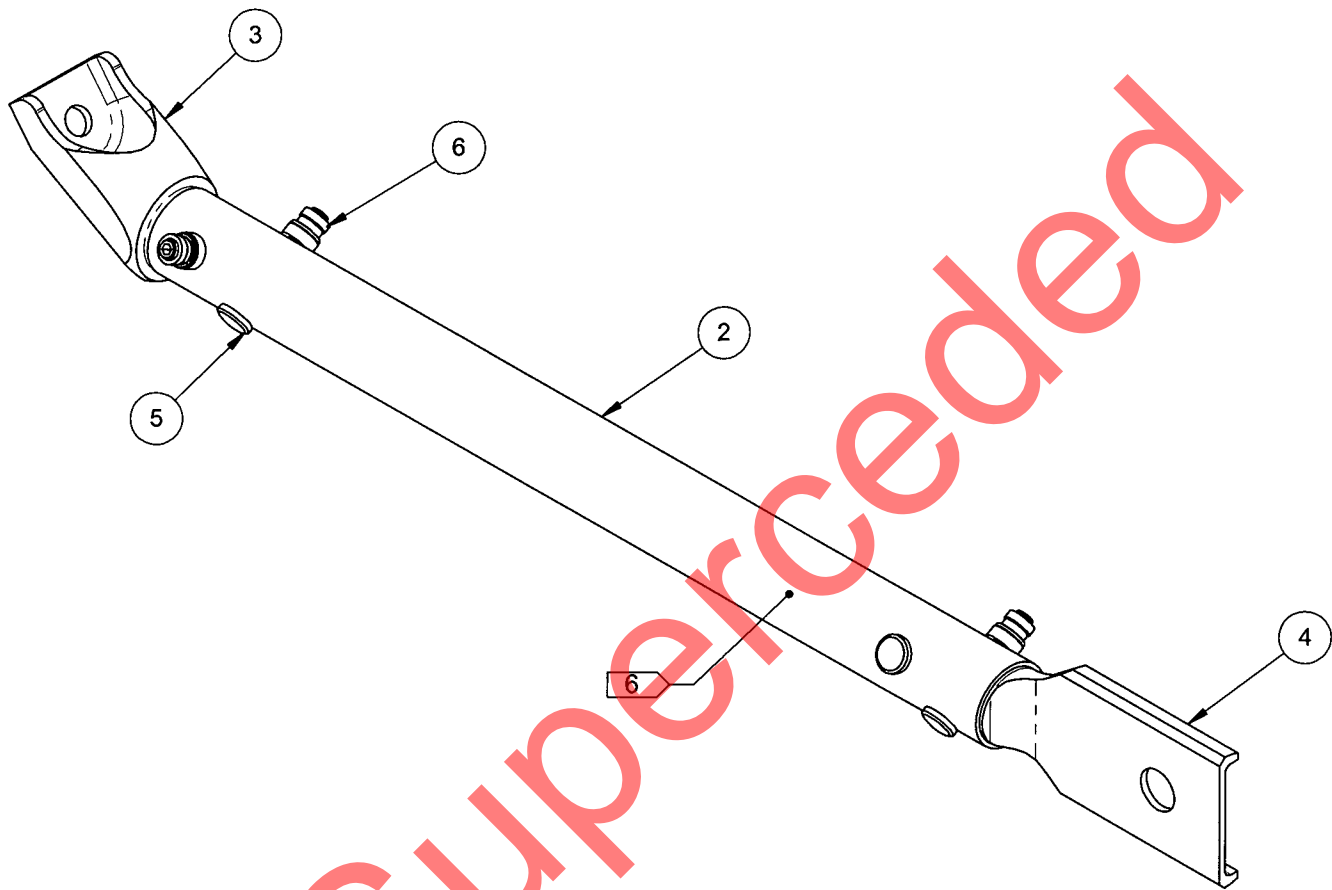


ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4878-041	FWD LEG ASSEMBLY, LH
2	1	D4878-1	STRUT
3	1	D4883-1	END FITTING
4	1	D4884-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4878-041 FWD LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-101-001) B

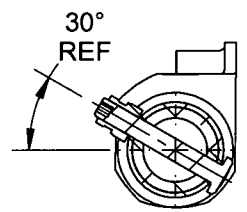
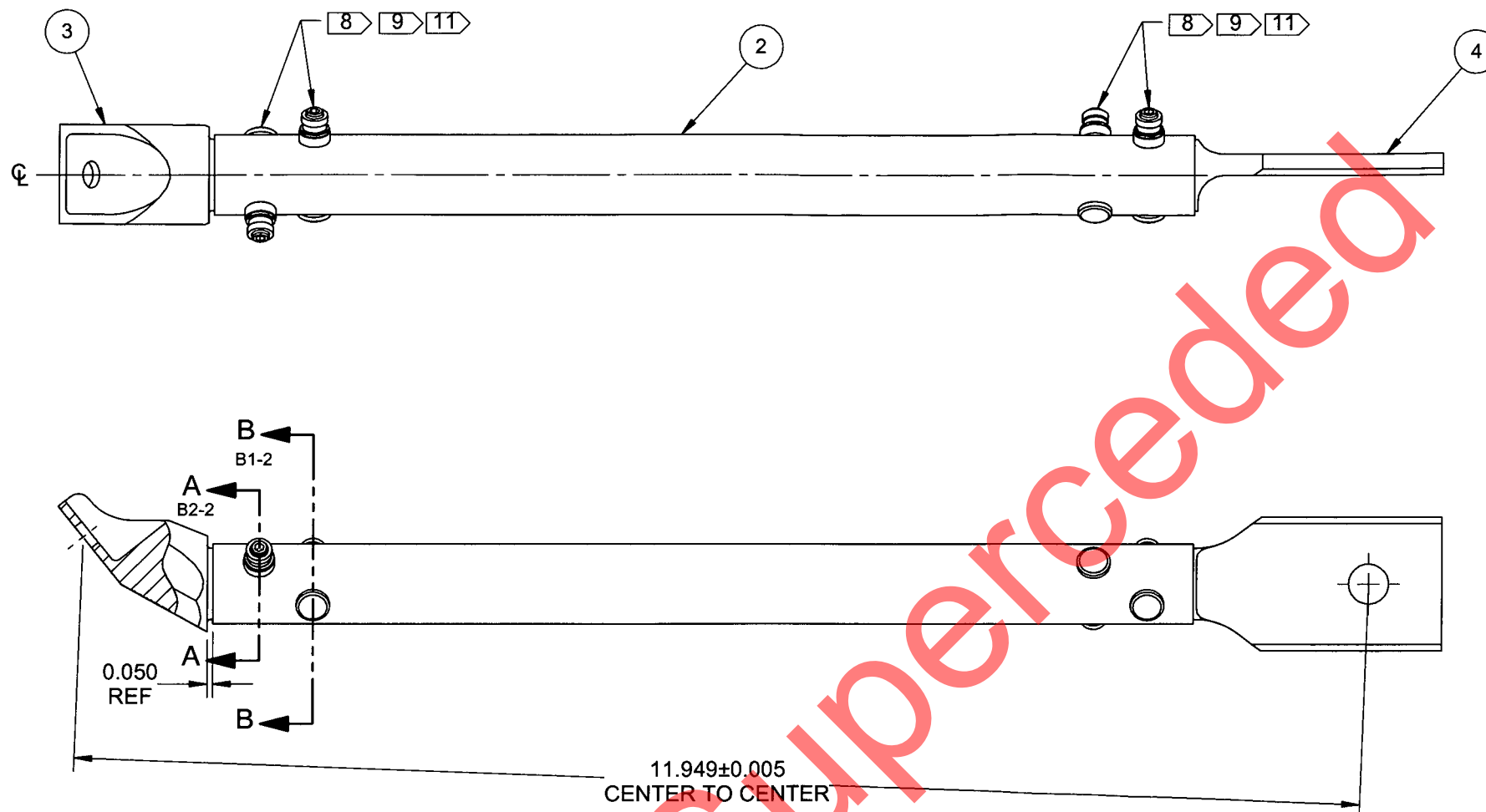
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2014-06-16
[Signature]

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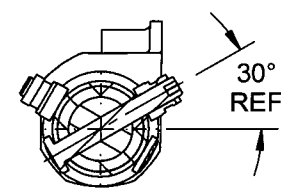
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.71 lbs
- 8) ALIGN PILOT HOLES IN D4878-1 WITH PILOT HOLES IN D4883-1 & D4884-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9966
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9966
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4878	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION A-A C7-2
2 PL, SIMILAR



SECTION B-B C7-2
2 PL

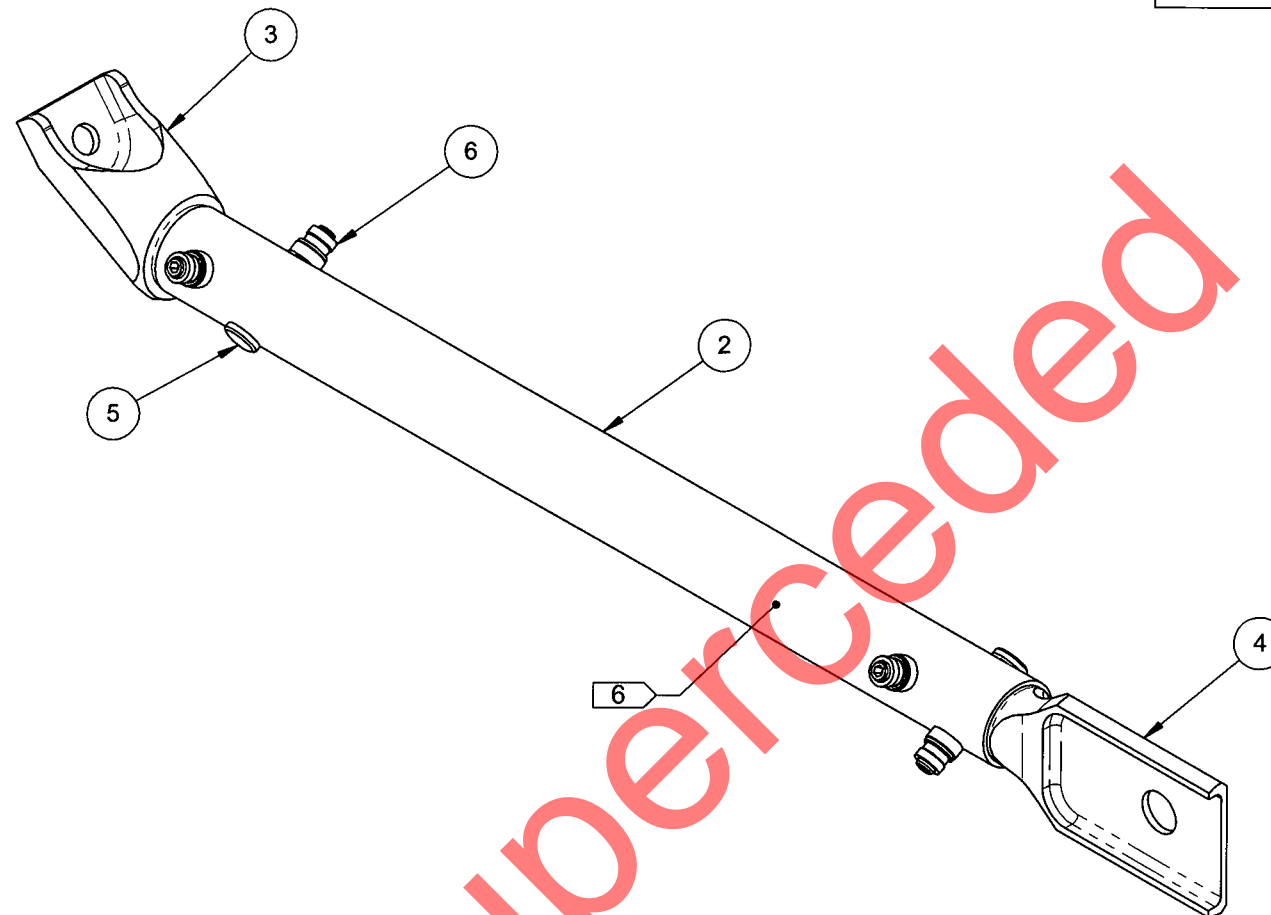
D4878-041 FWD LEG ASSEMBLY, LH
AUXILIARY VIEW

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2014-06-16
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4878	REV. B
MFG. APPR.	JFS		SHEET 2 OF 5
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4878-042	FWD LEG ASSEMBLY, RH
2	1	D4878-1	STRUT
3	1	D4883-1	END FITTING
4	1	D4884-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4878-042 FWD LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-101-002) B

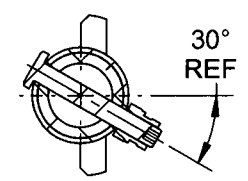
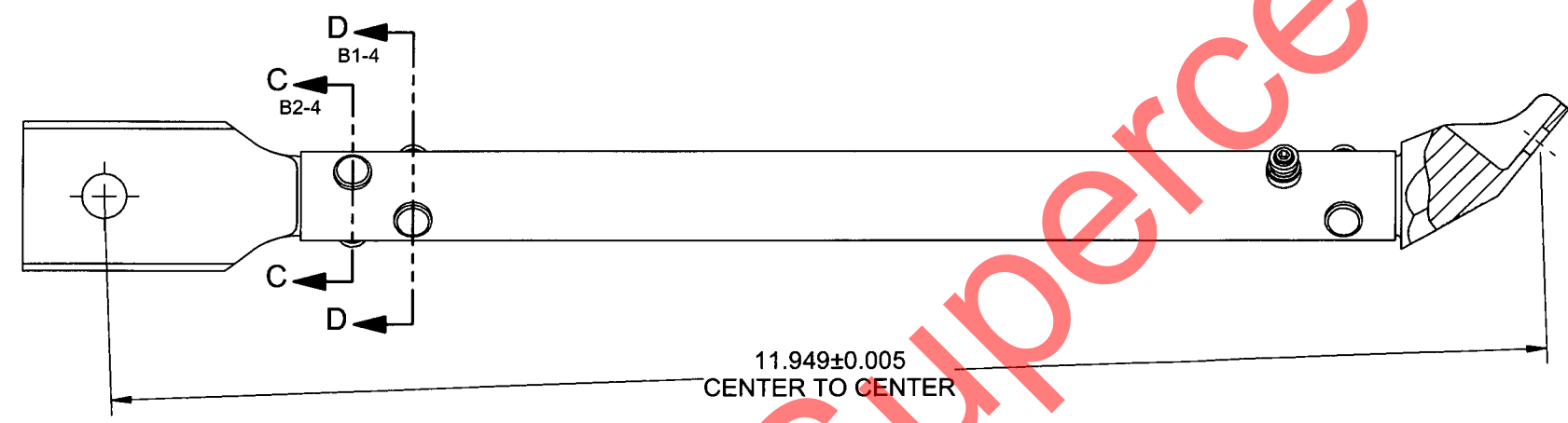
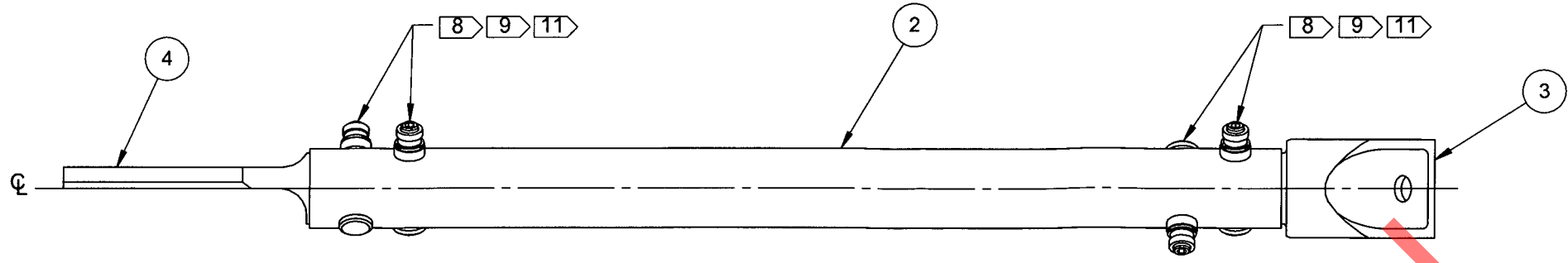
NOTES:

- 1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
7) WEIGHT: 0.71 lbs
8) ALIGN PILOT HOLES IN D4878-1 WITH PILOT HOLES IN D4883-1 & D4884-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (\varnothing 0.1610) REAMER, USING DART TOOL SETUP DT9967
B 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
10) ASSEMBLE PER DART TOOL DT9967
11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

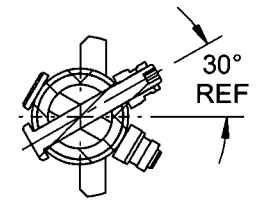
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4878	REV. B
MFG. APPR.	JFS	SHEET 3 OF 5	
APPROVED	HS	TITLE	SCALE
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SECTION C-C C7-4
2 PL, SIMILAR



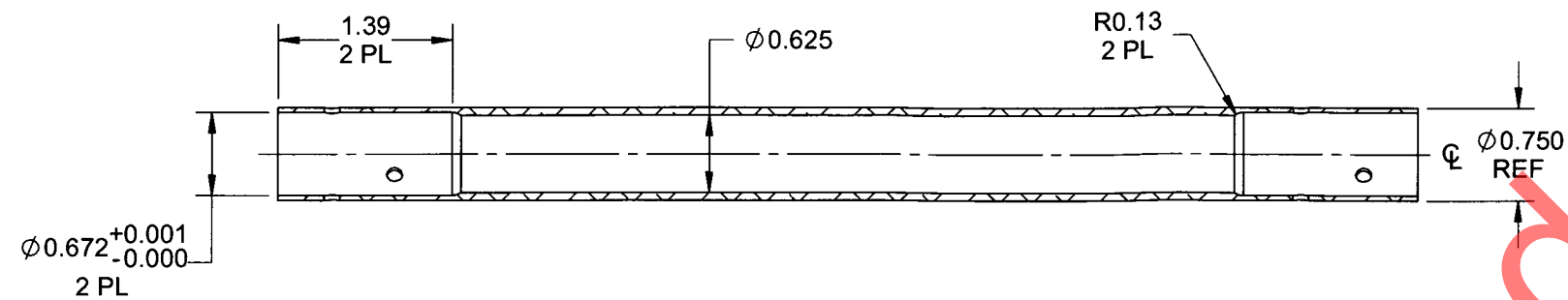
SECTION D-D C7-4
2 PL

D4878-042 FWD LEG ASSEMBLY, RH
AUXILIARY VIEW

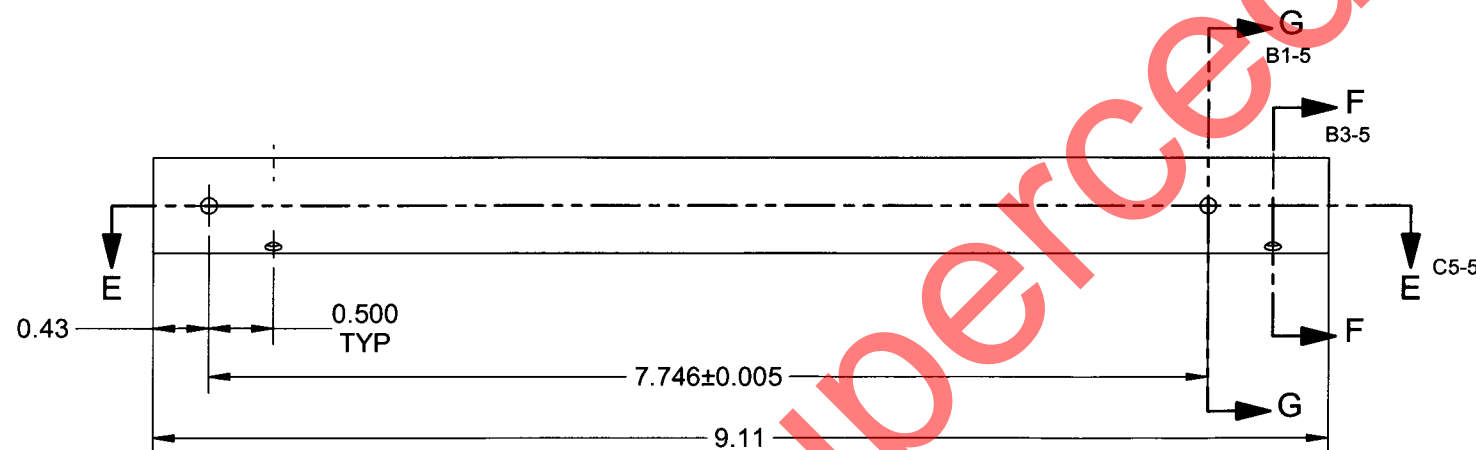
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2014 -06- 16
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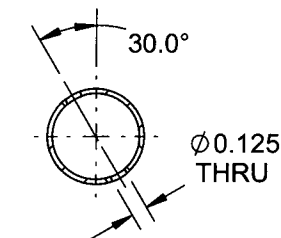
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DRAWN	RF		
CHECKED	VS	DRAWING NO. D4878	REV. B
MFG. APPR.	JFS		SHEET 4 OF 5
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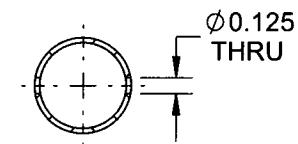
SECTION E-E C4-5



D4878-1 STRUT



SECTION F-F C4-5
2 PL



SECTION G-G C4-5
2 PL

- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.31 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-06-16

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4878	SHEET 5 OF 5
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